

Abstract

In the invention, a method is provided for producing a composite nonwoven fabric. A polymer is extruded into heated
5 continuous filaments, possibly elastic, from the die head to a first chilled roller, wherein the extruder is configured to provide the continuous filaments to the chilled roller in a canted direction that is at a tangent or angle to the surface of the first chilled roller. The filaments are conveyed in a downward direction by way of chilled
10 rollers to a nip. In a next step, the nonwoven web is sprayed with an adhesive and is laminated on the continuous filaments in the nip to form a composite nonwoven fabric. The continuous filaments move vertically downward approximately in line with the lamination process, facilitating automatic re-threading of filaments when they are broken or interrupted in their travel downward onto the chilled rolls.
15

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